

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020713**Date Inspected:** 18-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Wang Xu.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3007B

Weld No: 131

Welder: 055564 and 055491

WPS-B-T-2232-ESAB

PCMK: SA-3357

Weld No: 019

Welder: 070046

WPS-B-T-2233-ESAB

PCMK: SEG-3013AW

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Weld No: 041
Welder: 069712
WPS-B-T-2132-ESAB

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Wang Xu.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3007AB
Weld No: 016 and 087
WR: 20166
Welder: 037743
WPS-345-SMAW-3G(3F)-FCM-Repair-1

PCMK: SEG-3007L
Weld No: 062 and 066
Welder: 066163
WPS-B-P-2213-B-U2-FCM-1

PCMK: SEG-3019AA
Weld No: 025
CWR: 2755
Welder: 215553
WPS-345-SMAW-2G(2F)-FCM-Repair

PCMK: SEG-3019Z
Weld No: 012
CWR: 2755
Welder: 066418
WPS-345-SMAW-2G(2F)-FCM-Repair

PCMK: SEG-3019Z
Weld No: 014 and 015
CWR: 2755
Welder: 067656
WPS-345-SMAW-2G(2F)-FCM-Repair

PCMK: SEG-3019BB
Weld No: 115
Welder: 067616
WPS-B-P-2214-FCM-1

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PCMK: SA-3362
Weld No: 011
Welder: 067616
WPS-B-P-2214-FCM-1

PCMK: SEG-3019Z
Weld No: 007
Welder: 037932
WPS-B-P-2214-TC-C5B-FCM

Bay 14 West

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3020BB
Weld No: 109
Welder: 067764 and 067949
WPS-B-T-2233-ESAB

PCMK: SEG-3013P
Weld No: 011
Welder: 067876 and 066421
WPS-B-T-2132-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3020L
Weld No: 030
Welder: 067609
WPS-B-P-2114-FCM-1

PCMK: DP-3174-001
Weld No: 018
Welder: 037780
WPS-B-P-2212-TC-U4B-FCM

PCMK: DP-3174-001

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Weld No: 019
Welder: 066480
WPS-B-P-2212-TC-U4B-FCM

PCMK: SEG-3020BB
Weld No: 046
CWR: 2752
Welder: 066038
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3020BB
Weld No: 055
CWR: 2752
Welder: 045246
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Bay 16

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in bay 16;

BP-3095-001 and BP-3101-001

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Bay 19

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in bay 19;

BK-004A-014, BK-004A-013, BK-004B-001, BK-005A-002, SB-108E, SB-106E, and SB-106W.

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Bay 28

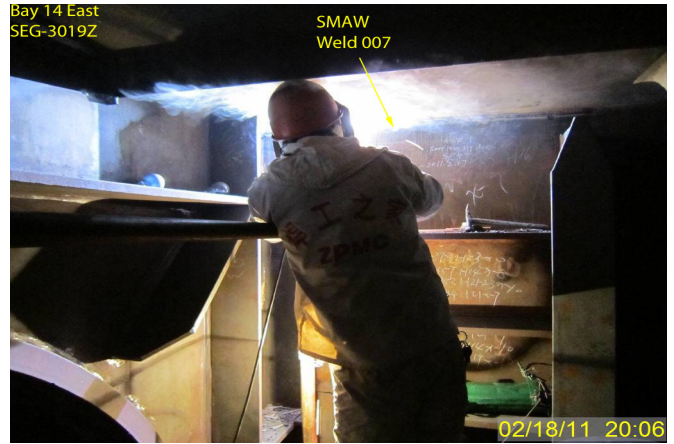
During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) a total of approx. 150 +/- Splice Plates for U-Ribs at this location in bay 28;

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
